

FED. SUPPLY CLASS

5305

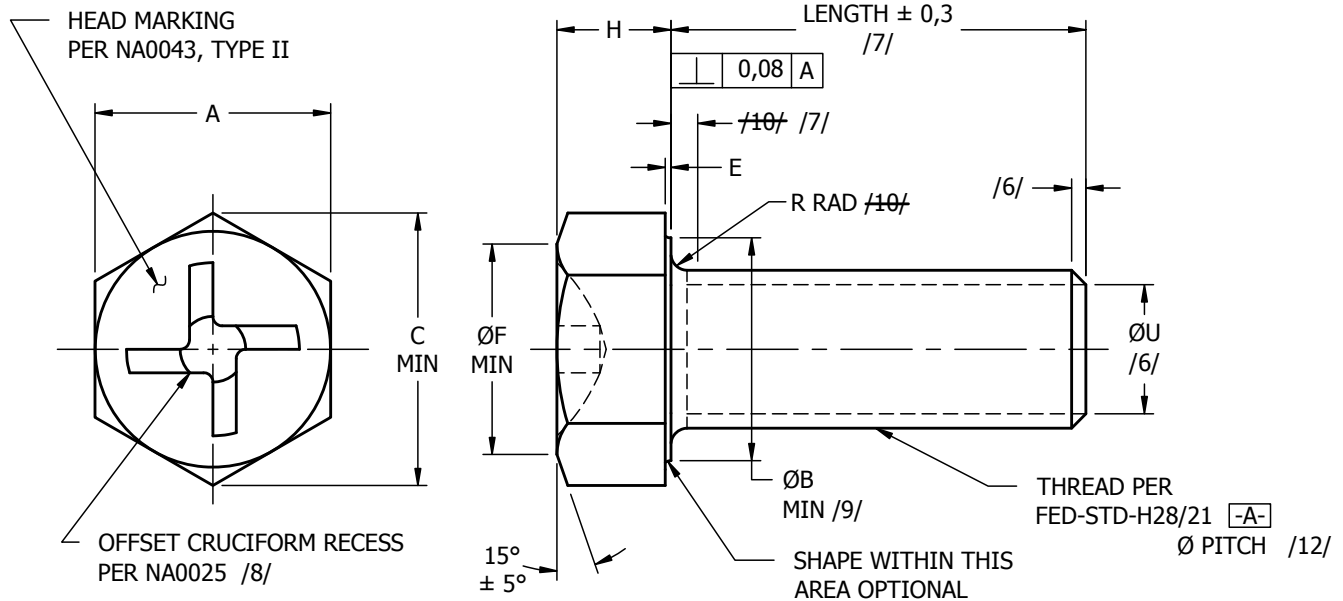


TABLE I – DIMENSIONS

DIA CODE /5/	THREAD 4h6h	A	$\varnothing B$ MIN /9/	C MIN	E	$\varnothing F$ MIN	H	R RAD	$\varnothing U$	RECESS		TENSILE FORCE N MIN
										RECESS NO.	INSPECTION TORQUE Nm /8/	
030 A030	MJ3 x 0,5	6,00 5,88	5,4	6,5	0,4 0,2	5,5	2,0 1,7	0,4 0,2	2,3 1,8	4	1,8	6-160 4 930
040 A040	MJ4 x 0,7	7,00 6,85	6,4	7,6	0,5 0,2	6,5	2,5 2,2	0,4 0,2	3,0 2,5	8	4,2	10-900 8 720
050 A050	MJ5 x 0,8	8,00 7,85	7,4	8,7	0,5 0,2	7,5	3,0 2,7	0,5 0,3	3,9 3,4	10	5,6	17-400 13 900
060 A060	MJ6 x 1	10,00 9,78	9,3	10,9	0,5 0,2	9,4	3,5 3,2	0,7 0,5	4,7 4,2	1/4	14	24-800 19 800
070 A070 /11/	MJ7 x 1	11,00 10,73	10,2	12,0	0,5 0,2	10,3	4,0 3,7	0,7 0,5	5,7 4,7	1/4	14	34-550 27 900

THIRD ANGLE PROJECTION	
PROCUREMENT SPECIFICATION	
NOTED	

CUSTODIAN	NATIONAL AEROSPACE STANDARDS COMMITTEE
TITLE	SCREW, DUAL WRENCHING, HEX HEAD/OFFSET CRUCIFORM, A286 CRES, FULL THREAD, 1100 MPa, METRIC

REVISION	7
CLASSIFICATION PART STANDARD	
DI0067	
SHEET 1 OF 3	

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

THIS DRAWING SUPERSEDES ALL ANTECEDENT STANDARD DRAWINGS FOR THE SAME
PRODUCT AND SHALL BECOME EFFECTIVE NO LATER THAN SIX MONTHS FROM THE LAST
REVISION DATE.

FORM 12-01

REVISION DATE: JANUARY 30, 2015

ISSUE DATE: DECEMBER 1979

MATERIAL:

CRES – A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.

HEAT TREATMENT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS-H-6875 OR AMS2759: 1100-1310 MPa Ft_u.

FINISH:

PASSIVATE PER AMS2700, METHOD 1, CLASS 4.

CODE:

FIRST THREE NUMBERS DESIGNATE NOMINAL THREAD SIZE AS TABULATED.
SECOND THREE NUMBERS DESIGNATE NOMINAL LENGTH IN EVEN NUMBER INCREMENTS. SEE TABLE II FOR RECOMMENDED LIMITS.

EXAMPLE OF PART NUMBER:

⑦ NA0067 030016 — SCREW: M3 x 0,5, 16 mm LONG /5/
NA0067 A030016 = SCREW: M3 x 0,5, 16 mm LONG

NOTES:

- (1) SURFACE ROUGHNESS: BEARING SURFACE OF HEAD, HEAD TO SHANK FILLET RADIUS AND ALL THREAD ELEMENTS: 0,8 µm Ra; ALL OTHER SURFACES: 3,2 µm Ra PER ASME B46.1.
- (2) MAGNETIC PERMEABILITY SHALL BE LESS THAN 2,0 (AIR = 1,0) FOR A FIELD STRENGTH H = 16 K A/m USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, METHOD 3.
$$1 \text{ OERSTED} = \frac{1000}{4\pi} \frac{\text{A}}{\text{m}}$$
- (3) REMOVE ALL BURRS AND BREAK EDGES 0,1 TO 0,4.
- (4) DIMENSIONS IN MILLIMETERS AND APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.
- /5/ NON "A" PREFIXED DIAMETER CODES CANCELED AFTER APRIL 15, 1993. NO SUPERSEDING STANDARD. FOR DESCRIPTION OF STATUS NOTES SEE NAS10000.
- /6/ ~~INCOMPLETE THREADS IN ACCORDANCE WITH FED-STD-H28/21. POINT SHALL BE FLAT AND CHAMFERED TO APPROXIMATELY 45° FROM "ØU".~~
- /7/ FOR SCREWS 36 mm IN LENGTH OR LESS, THREAD TO HEAD. LONGER SCREWS SHALL HAVE A MINIMUM THREAD LENGTH OF 36 mm. DIAMETER OF UNTHREADED PORTION SHALL NEITHER BE LESS THAN MINIMUM PITCH DIAMETER NOR MORE THAN MAXIMUM MAJOR DIAMETER OF THREAD.
- /8/ RECESS SHALL BE TORQUE-TESTED IN BOTH INSTALLATION AND REMOVAL DIRECTIONS WITH APPLICABLE DRIVE AND AXIAL END PRESSURE NOT EXCEEDING 66 N. SCREWS ARE REJECTABLE IF MINIMUM TORQUE VALUES SPECIFIED CAUSE FRACTURE OF FASTENER OR DISTORTION WHICH RESULTS IN RAISE OF METAL AT EDGE OF RECESS EXCEEDING 0,15 ABOVE SURROUNDING AREA. SAMPLING SHALL BE PER ASQ Z1.4, 4% AQL, LEVEL S-1.

REVISION

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Documents

SHEET 2

Document Sharing Hub